

duplicate

Date: Monday, 14/04/2008 9:06:35 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LOW PROFILE BASKET LID ASS'Y
Job Number	: 38461		
Estimate Number	: 13153		
P.O. Number	:	Part Number	: D3713042
This Issue	: 14/04/2008 S.O. No. :	Drawing Number	: D3713 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 08/04/2008 Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 38218	Material	:
Written By	:	Due Date	: 25/04/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JO 08.4.14</u>		
Comment	: Est Rev:A new issue 08-01-30 DD verified by:EC Est Rev:B change to revB ecn 1145 08-03-19 DD verified by:		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.5731 f(s)/Unit Total : 32.5731 f(s)
304 SQ Tube.75x.75x.065W

1- Cut Ribs as per dwg from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

QTY	PART NUMBER	BATCH
2	D3714-1	<u>M107514</u>
2	D3715-1	<u>M107514</u>
10	D3716-1	<u>M107514</u>
4	D3732-1	<u>M107514</u> ✓

2- Deburr

JS 08/04/18

2.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer Bushing
batch B36920 ✓

CP 08.04.22

3.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Mounting Bracket
batch B37248 ✓

CP 08.04.22

Date: Monday, 14/04/2008 9:06:35 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 38461

Part Number: D3713042

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0	D37491	HINGE HALF
-----	--------	------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
HINGE HALF
batch 337202 ✓

Pl 08.04.22

5.0	D2329	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label Plate
batch 335686 ✓

Pl 08.04.22

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

- 1- drill holes in both D3715-1 as per dwg D3715
- 2- deburr
- 3- assemble as per dwg D3713 and weld as per QSI004

Pl 08.04.22

7.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 17.8500 sf(s)/Unit Total : 17.8500 sf(s)
Expanded Metal Flat Stainless Steel
Pick:

Qty	Part Number	Description	Batch
17sq.ft	M304EX0.75-16F	Expanded Metal	<u>M107316</u> ✓

SAD 08/04/22

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

- 1- cut mesh as per dwg D3743 - *SAD 08/04/22* ①
- 2- weld mesh as per dwg D3713 ✓

Pl 08.04.23
JS 08/04/24

Date: Monday, 14/04/2008 9:06:35 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LOW PROFILE BASKET LID ASS'Y

Job Number: 38461

Part Number: D3713042

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/24

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

A 08/04/24

11.0

POWDER COATING

POWDER COATING



M 100700



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

HP 08-04-2

B38461
D3713042
25/04/2008
07.44

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/04/24

#1
#2
#3
#4
323.7
30mins

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3713 and QSI 005 4.4

M 08-04-25

①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/04/28

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 08/04/28

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

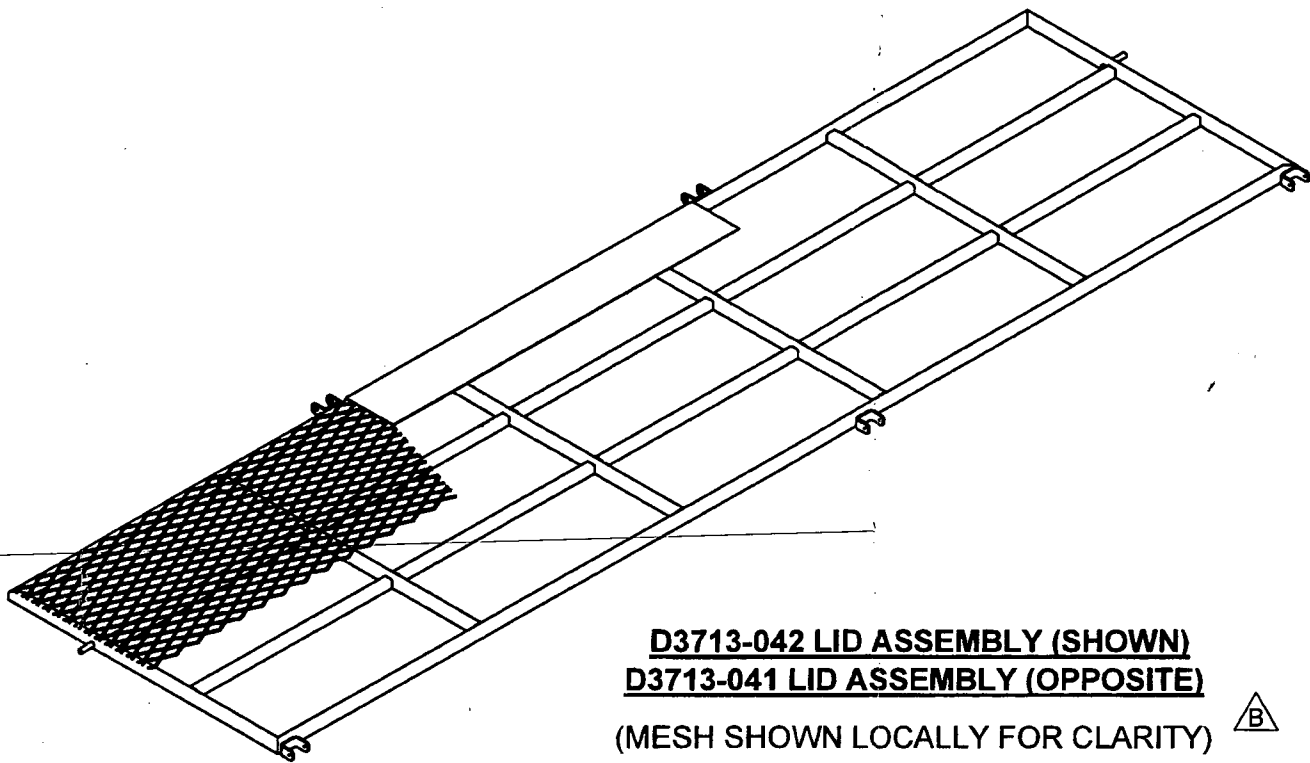
08/04/28

Job Completion



U 08-04-28

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF



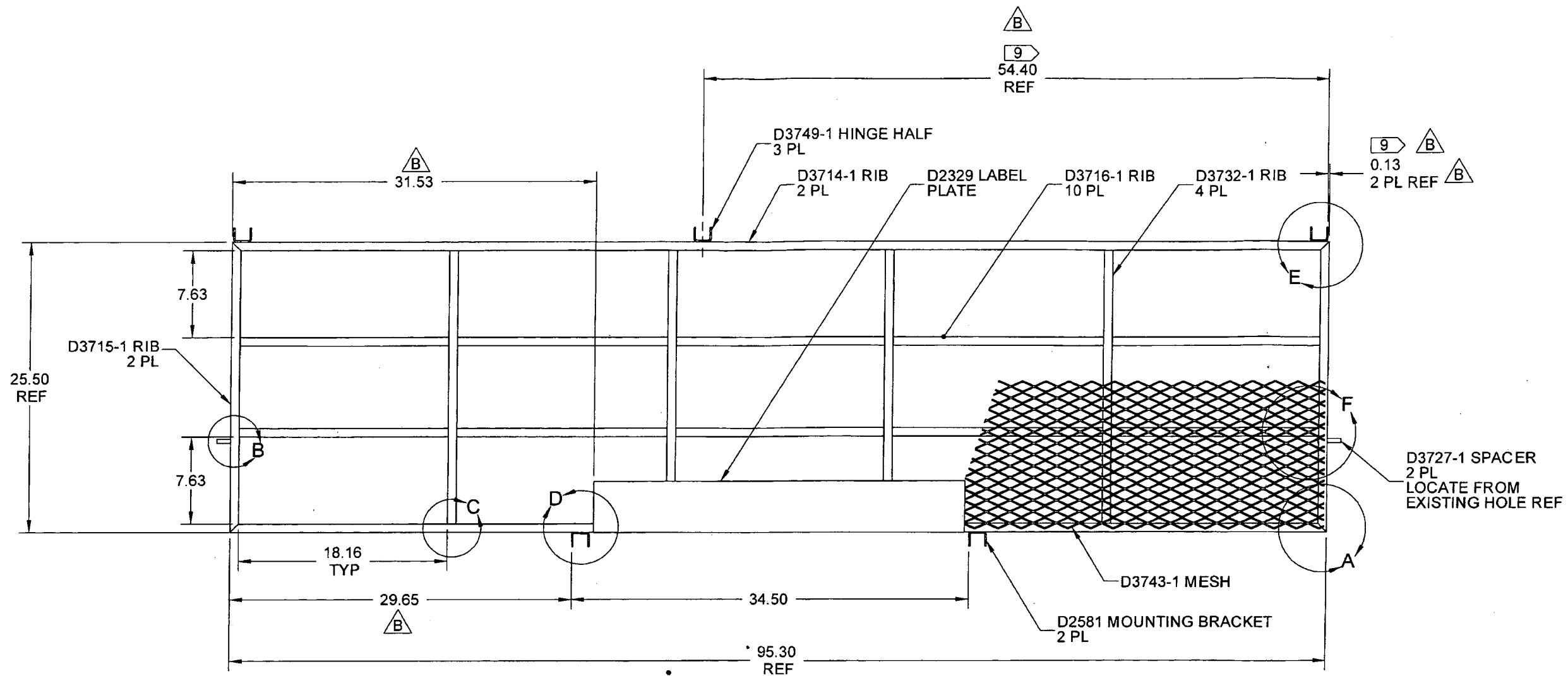
D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38461

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

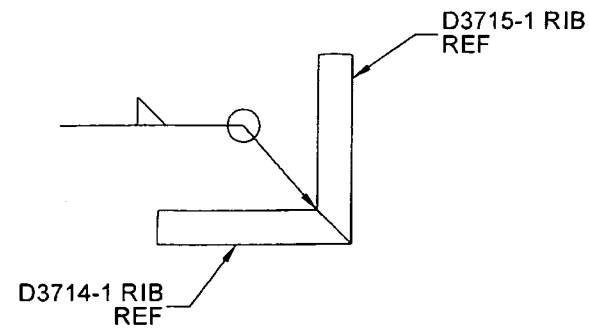
B	SHEET 1 -042 WAS -041; ADDED CORRECT -041 ASSEMBLY, NOTE 9 ADDED, ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041, ZONE D6 31.53 DIM WAS 31.64, ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.77, ZONE D3 & D2 FLAG NOTE 9 ADDED.	AJS	08.02.27
A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	MS	D3713	SHEET 1 OF 3
APPROVED	MD	TITLE	SCALE
DE APPR.	JH	LID ASSEMBLY	NTS
DATE	08.02.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



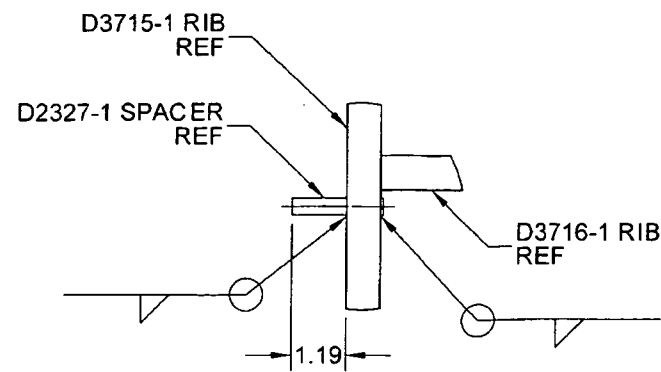
D3713-042 LID ASSEMBLY (SHOWN) B
D3713-041 LID ASSEMBLY (OPPOSITE)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38461

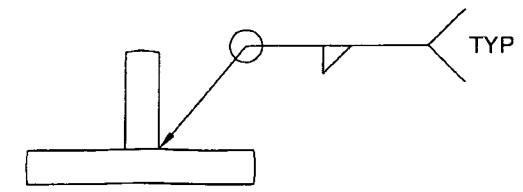
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.	AP	D3713	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LID ASSEMBLY	NTS
DATE	08.02.27	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



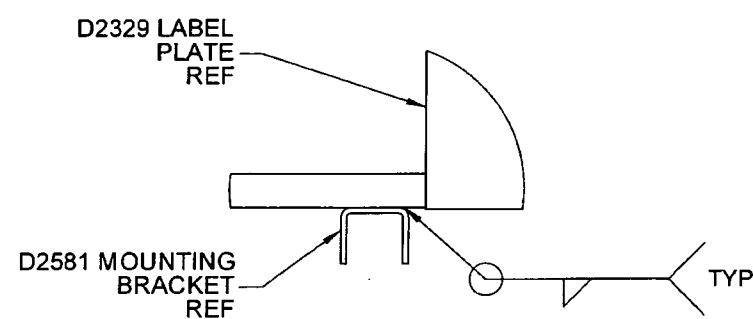
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



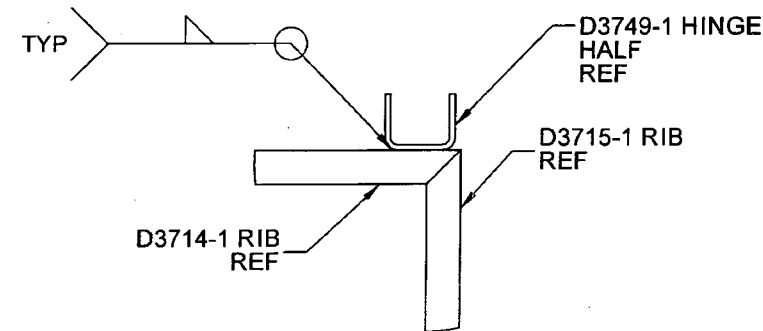
DETAIL B
TYP BOTH ENDS
SCALE 4X



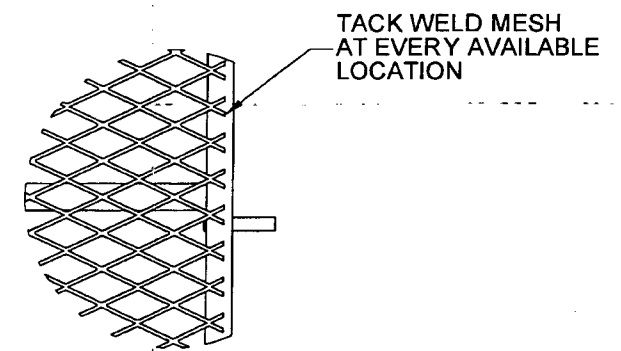
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X



DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

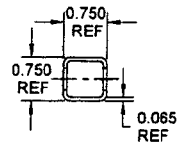
TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38461

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AE	DRAWING NO. D3713	REV. B
MFG. APPR.	AE	SHEET 3 OF 3	
APPROVED	AE	TITLE	SCALE
DE APPR.	AE	LID ASSEMBLY	NTS
DATE	08.02.27	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

0.75 X 45° CMF
2 PL

25.50



Ø0.375
THRU

0.38

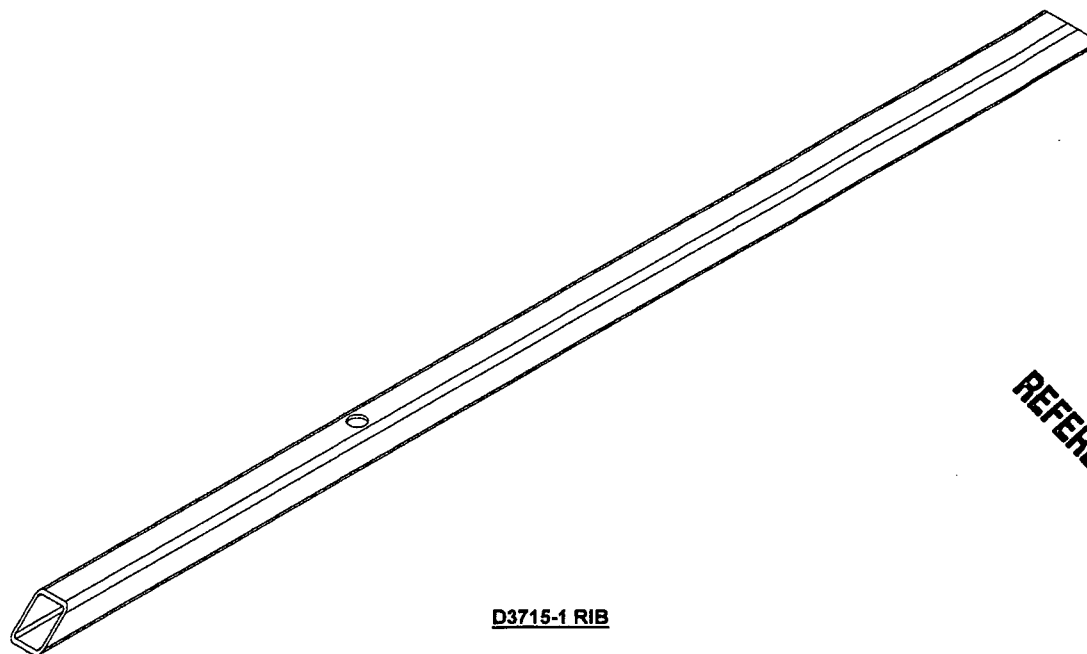
8.00

D3715-1 RIB

REFERENCE ONLY

RELEASED
08.02.25

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ME	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D3715	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	RIB	1:2
DATE	08.02.01	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR REPRODUCTION OR COMMERCIAL USE WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3715-1 RIB

REFERENCE ONLY

RELEASED
08.02.01

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
(REF. DART SPEC. M304TS0.750W0.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	DP	D3715	SHEET 1 OF 2
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	RIB	NTS
DATE	08.02.01	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	